



007004

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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RBT400314
Job Sheet 187662



Part No: RBT400314

Job Qty: 1 ea

Part Name: Main Transmission Backlash Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/11/18

Job Tracking No:

Due Date: 12/21/18

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG RBT400314 Rev A IPP Rev A 18.02.28 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		12/21/18	0.00	0.00	Start Up Small Fab-2		MLL
110	Small Fab	1 pcs		12/21/18	0.00	1.00	Small Fab-3		MLL DAS
120	QC	1 pcs		12/21/18	0.00	0.00	QC5		JAN 09 2019 68
130	Packaging	1 pcs		12/21/18	0.00	0.00	Packaging3-1		DAS 9-89
140	QC21-SA	1 Ea		12/21/18	0.00	0.00	QC21		28 9-89

Part Op
Descriptions: 110 - 1-Assemble as per DWG.

JAN 10 2019

DAS

21

9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBT400314-1	Plate Weldment	1 Ea (1 ea)	90-Start up Operation	5066981
91247A235	Hex Head Cap Screw	4 pcs (4 ea)	110-Small Fab	5048600
91257A565	Hex Head Cap Screw	2 pcs (2 ea)	110-Small Fab	5048598
94191A150	Hex Nut 1/4-28 UNF	2 pcs (2 ea)	110-Small Fab	5010649
95229A430	Washer Rnd 1/4" Id Cad Plated	2 Ea (2 ea)	110-Small Fab	5048599
95229A490	Flat Washer	4 pcs (4 ea)	110-Small Fab	5084067
95505A613	Hex Nut	4 pcs (4 ea)	110-Small Fab	5048602
98032A481	Flat Washer	2 pcs (2 ea)	110-Small Fab	5048603
99638A100	Hex Nut	1 pcs (1 ea)	110-Small Fab	5048604
AN3-23A	Hex Head Cap Screw	1 Ea (1 ea)	110-Small Fab	M112314
RBT400314-7	Clamp	1 Ea (1 ea)	110-Small Fab	5049857



Container No: S136763



Part: RBT400314

Job No: 187662

Serial No/Batch: S136763

Revision: A

Inspector:

Exp Date:

Instructions:

DART Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 12/11/18

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Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation 110-Small Fab	RBT400314-1	1	2	0
	91247A235	4	10	0
	91257A565	2	50	0
	94191A150	2	11	0
	95229A430	2	96	0
	95229A490	4	200	0
	95505A613	4	96	0
	98032A481	2	98	0
	99638A100	1	4	0
	AN3-23A	1	110	0
	RBT400314-7	1	11	0

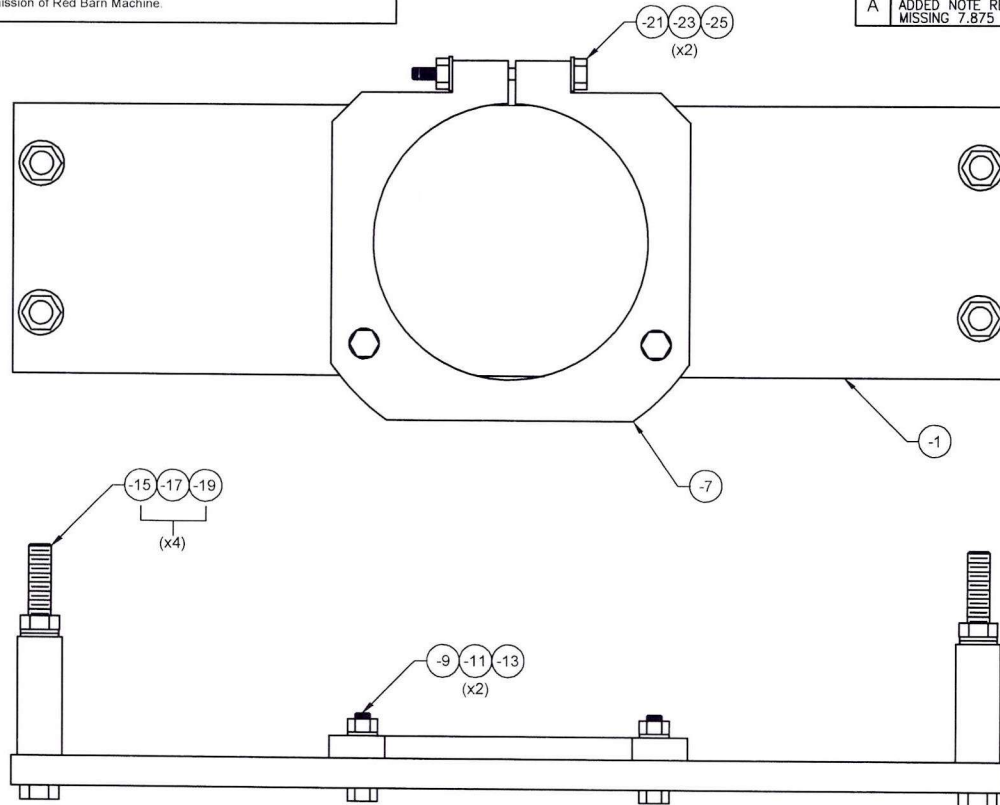
Part Specifications

Specifications could not be found.

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
A	ADDED NOTE REF. ORIGINAL BELL NUMBER 204-040-001-17-PAT-1 PER S.E. ADDED -3 MISSING 7.875 DIMENSION PER G.E.	5/14/12	RJC
			SE



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WORK ORDER
NO. 173346 *hws*
1802-28

ASSEMBLY

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
			-1	1	PLATE WELDMENT			2
1			-3		PLATE	6061	1/2 x 4-1/2 x 16-7/8	3
4			-5		POST	6061	Ø3/4 x 2-1/8	4
			-7	1	CLAMP	6061	3/8 x 6 x 6-1/8	5
B/O			-9	2	HEX HEAD CAP SCREW	STEEL GRD 8	1/4-28 UNF-2A x 1-1/4 MCMaster-CARR #91257A565	1
B/O			-11	2	FLAT WASHER	STEEL	1/4 I.D. x 1/2 O.D. x 1/16 MCMaster-CARR #95229A430	1
B/O			-13	2	HEX NUT	STEEL	1/4-28 UNF-2B MCMaster-CARR #94191A150	1
B/O			-15	4	HEX HEAD CAP SCREW	STEEL GRD 5	3/8-24 UNF-2A x 4 MCMaster-CARR #91247A235	1
B/O			-17	4	FLAT WASHER	STEEL	3/8 I.D. x 5/8 O.D. x 1/16 MCMaster-CARR #95229A490	1
B/O			-19	4	HEX NUT	STEEL	3/8-24 UNF-2B MCMaster-CARR #95505A613	1
B/O			-21	1	HEX HEAD CAP SCREW	STEEL	10-32 UNF-3A x 2-13/32 AIRCRAFT SPRUCE #AN3-23A	1
B/O			-23	2	FLAT WASHER	STEEL	Ø1/4 I.D. x 9/16 O.D. x 1/16 MCMaster-CARR #98032A481	1
B/O			-25	1	HEX NUT	STEEL	10-32 UNF-3B MCMaster-CARR #99638A100	1

NOTES:

1. REF. ORIGINAL BELL #204-040-001-17-PAT-1.

RED BARN MACHINE

TITLE MAIN XSMN BACKLASH TOOL

DWG NO. RBT400314 REV A

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ON:
DECIMALS .XXX ± .005
XX ± .01
X ± .1
METRIC REF.
XXmm ± .1mm
FRACTIONS ± 1/32
ANGLES ± 5°
DRAWN BY: CLOUGH
APPROVED: *D Wed*
HEAT TREAT
FINISH
SPEC

UNLESS OTHERWISE SPECIFIED
1. BREAK ALL SHARP EDGES
.015 x 45° PR .015 R
2. DIMENSIONAL LIMITS APPLY AFTER PLATING
USED ON MODEL
BELL 204, 205, 212

SCALE NTS DATE 1-10-11 SHEET 1 of 5